

Date: Wednesday, 7/19/2006 2:07:10 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27981
Estimate Number : 12378
P.O. Number : N/A
This Issue : 7/19/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LANDING GEAR
Previous Run : N/A

Drawing Name

Part Number : D206667203A
Drawing Number : DSI9326
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 7/26/2006

Qty: 1 Um: Each

Written By : SKA COMMENT (Bldg)
Checked & Approved By : 06.07.19
Comment : Est Rev:A New Issue 06-04-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD206-667-203A CHG001
Add DSI 9326 to existing paper work.

2.0 D206667203 Crosstube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Fwd Crosstube
Batch: B25006

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
1-Remove tube from packaging

2-Apply Armor shield as per DSI 9326
A/R Armor Shield Batch: M101241

4.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D206-667-203A
Location: _____
PPP Rev: p part

DART		TEL: 1-613-632-8336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL #09-89			
PN	D206-667-203	CHG	CHG002
DESC	Crosstube Aft High	STC	SH01-5
LOT	B25006	STC	SR01304NY
MODEL	Bell 206L/L1/L3/L4	STC	
MADE IN CANADA			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *LD* Date: 06/07/25

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 7/19/2006 2:07:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMOR SHIELD

Job Number: 27981

Part Number: D206667203A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: 26/07/05 (7)

Job Completion



Handwritten: 06.07.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J.J.</i>	APPROVED <i>J.J.</i>	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14		TITLE ARMOR SHIELD	SCALE NTS
A	06.02.14	NEW ISSUE	

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-664-101/-201 D412-664-203	SH01-9	SR01298NY
D206-667-101/-103/-201/-203 D407-667-105/-205	SH01-5	SR01304NY
D058-676-101/-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area.
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface (apply additional coats when surface is dry, but not fully cured)
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.

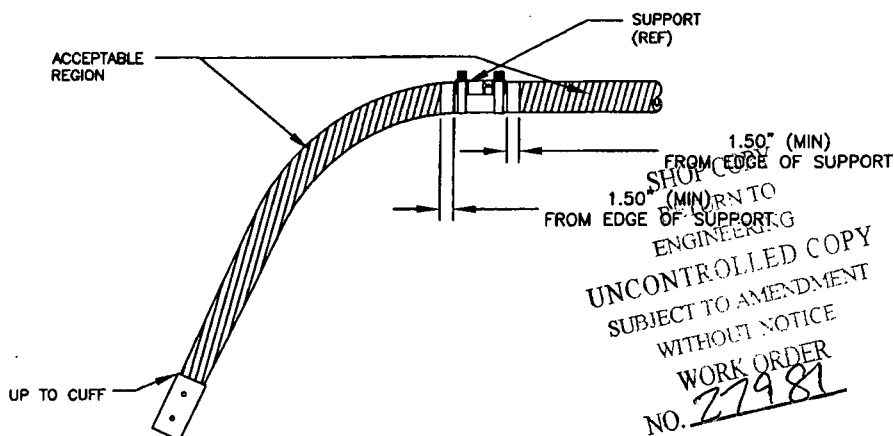


FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 06.02.14
CERT. NO.: SH03-6/SH01-9/SH01-5
ISSUE NO.: 3/3/3

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Date: Wednesday, 7/19/2006 2:07:10 PM
 User: Kim Johnston

Process Sheet

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Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARMOR SHIELD
 Job Number : 27981
 Estimate Number : 12378
 P.O. Number :
 This Issue : 7/19/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D206667203A
 First Issue : 1/1 Type : LANDING GEAR Drawing Number : DSI9326
 Previous Run : Drawing Revision : A
 Material :
 Due Date : 7/26/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 06.07.19
 Comment : Est Rev:A New Issue 06-04-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD206-667-203A CHG001
 Add DSI 9326 to existing paper work.

06.07.19

2.0 D206667203 Crosstube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Fwd Crosstube
 Batch: _____

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 1-Remove tube from packaging

2-Apply Armor sheild as per DSI 9326
 A/R Armor Sheild Batch: _____

REFERENCE ONLY

4.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and pack for shipping as per PPP D206-667-203A
 Location: _____
 PPP Rev: _____